

CLAIMS

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) Device for continuous manufacture of drip irrigation tubes, comprising an extruding device (1) for producing a tube body (2), a calibrating device (3), and a cooling device (19) for the tube body (2), a feed apparatus (5) for feeding dosing elements (6) into the tube body (2) along a guideway (4), and means for connecting the dosing elements (6) to the inner walling of the tube body (2), comprising a pressing element (17) which is formed by the end area of the guideway (4) and which protrudes into the extruded tube body (2), and a pressing roller (18) which is able to be pressed against the tube body (2) from the exterior in the region of the pressing element (17), the calibrating device (3) being formed by a tubular body (22) whose feed region (23) narrows to the desired diameter of the tube body (2) and whose longitudinally elongated body area (24) protrudes into the cooling device (19), and is provided with a recess (27) into which the pressing member (18) protrudes so that the pressing and connecting process of the dosing elements (9) with respect to the inner walling of the tube body (22) ensues inside the calibrating device (3), characterized in that the pressing roller (18) has an indentation (20), ~~which (20) that~~ which (20) that corresponds to the outer contour of the tube body (2) in the region of the calibrating device (3), and in that at least at the ~~and has a bottom of the indentation (20) of the pressing roller (18) provided with a marking structure (21) is applied running over the entire circumference, which the pressing roller (18) being configured to cause the marking structure is transferable to provide a mark on the surface of the tube body (2) in the region of the respective dosing element (6), and serves location of the position of so as to facilitate locating the respective dosing element (6) for putting in the in the tube body (2) when placing an outlet aperture through the tube body (22) and the respective dosing element (6).~~

2. (Original) Device according to Claim 1, characterized in that the recess (27) in the longitudinally elongated body area (24) of the tubular body (22) has the form of a slot which extends from the end (29) of the longitudinally elongated body area (24), protruding into the cooling device (19), to the walling (26) closing off the cooling device (19), through which the longitudinally elongated body area (24) is led into the cooling device (19).

3. (Previously Presented) Device according to Claim 1, characterized in that the pressing pressure of the pressing roller (18) against the tube body (2) is adjustable.

4. (Previously Presented) Device according to Claim 1, characterized in that the feed apparatus (4, 5) comprises a separating device (7), into which the next of the continuously fed dosing elements (6) is able to be captured in each case, ejected in a way guided onto the guideway (4), and inserted into the tube body (2) by means of an airstream along the guideway (4).

5. (Original) Device according to Claim 4, characterized in that the separating device (7) is made up of two drivable rollers (8, 9), disposed opposite one another, and in that in each case one dosing element (6') of the continuously fed dosing elements (6) is able to be captured by the two rollers (8, 9), brought into a waiting position, and ejected therefrom onto the guideway (4).

6. (Original) Device according to Claim 5, characterized in that installed in the guideway (4) is a sensor (13), with which the reaching of the waiting position of the respective dosing element (6') is detectable.

7. (Previously Presented) Device according to Claim 4, characterized in that the airstream is producible with air jets (14), which are formed by supply lines (15) that come out into the guideway (4), and in that the supply lines (15) are disposed such that the airstream coming out in each case hits the dosing element (6), to be advanced, at an angle of about 25°.

8. (Previously Presented) Device according to Claim 2, characterized in that the pressing pressure of the pressing roller against the tube body is adjustable.

9. (Previously Presented) Device according to Claim 2, characterized in that the feed apparatus comprises a separating device, into which the next of the continuously fed dosing elements is able to be captured in each case, ejected in a way guided onto the guideway, and inserted into the tube body by means of an airstream along the guideway.

10. (Previously Presented) Device according to Claim 3, characterized in that the feed apparatus comprises a separating device, into which the next of the continuously fed dosing

elements is able to be captured in each case, ejected in a way guided onto the guideway, and inserted into the tube body by means of an airstream along the guideway.

11. (Previously Presented) Device according to Claim 5, characterized in that the airstream is producible with air jets, which are formed by supply lines that come out into the guideway, and in that the supply lines are disposed such that the airstream coming out in each case hits the dosing element, to be advanced, at an angle of about 25°.

12. (Previously Presented) Device according to Claim 6, characterized in that the airstream is producible with air jets, which are formed by supply lines that come out into the guideway, and in that the supply lines are disposed such that the airstream coming out in each case hits the dosing element, to be advanced, at an angle of about 25°.

13. (New) Device according to Claim 1, wherein the marking structure comprises a pattern on the surface of the pressing roller configured to create a physical impression on the tube body.

14. (New) A device for continuous manufacture of drip irrigation tubes comprising:
an extruding device for creating an extruded tube body;
a calibrating device for creating a shaped outer contour of the extruded tube body;
a cooling device;
a guideway;
a dosing element feed apparatus; and
a device for attaching dosing elements to an extruded tube body, comprising:
a pressing element protruding into the extruded tube body; and
a pressing roller located adjacent an outside surface of the extruded tube body and configured to be in pressing opposition to the pressing element as a dosing element passes therebetween, the pressing roller comprising:
a concave surface corresponding to the shaped outer contour of the extruded tube body; and
a marking structure on a portion of the concave surface and extending along an entire circumference of the pressing roller, the marking structure

comprising a pattern on the surface of the pressing roller configured to create a physical impression on the surface of the extruded tube body in the region of a respective dosing element.

15. (New) The device of Claim 14, wherein the dosing element feed apparatus comprises a separating device configured to captured each dosing element and eject it along the guideway and an airstream configured to insert the dosing element into the tube body.

16. (New) The device of Claim 15, further comprising supply lines extending into the guideway, which produce the airstream.

17. (New) The device of Claim 16, wherein the supply lines are directed into the guideway such that the airstream hits the dosing elements at an angle of about 25°.

18. (New) The device of Claim 14, wherein the pattern of the marking structure is a fine knurl.

19. (New) A device for the continuous manufacture of drip irrigation tube having a tube body provided with inner and outer surfaces and a plurality of dosing elements longitudinally spaced apart within the tube body, comprising an extruding device adapted to continuously create the tube body, a placement device having at least a portion disposed within the tube body for selectively pressing the plurality of dosing elements in predetermined longitudinally spaced-apart positions against the inner surface of the tube body and a marking device for marking the outer surface of the tube body in the vicinity of each of the plurality of dosing elements for facilitating the location of the plurality of dosing elements when forming an aperture through the tube body at each of the plurality of dosing elements.

20. (New) The device of Claim 19 wherein the portion of the placement device includes a pressing element configured to successively receive each of the plurality of dosing elements for successively pressing each of the plurality of dosing elements against the inner surface of the tube body.

21. (New) The device of Claim 20 wherein the pressing element is spaced from the marking device so that as each of the plurality of dosing elements is received by the pressing element the pressing element urges such dosing element against the inner surface of the tube

body so as to cause the outer surface of the tube body opposite such inner surface to be urged against the marking device and thus cause the marking device to mark such outer surface of the tube body.

22. (New) The device of Claim 19 wherein the marking device includes a roller.

23. (New) The device of Claim 22 wherein the roller has an outer surface provided with a marking structure for marking the outer surface of the tube body.